



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

D4704-041
Job Sheet 161978



Part No: D4704-041

Job Qty: 2 ea

Part Name: Expandable Pin Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B 12.10.16 AS PER DWG REV:A DD VERF:JFS IPP REV:C 17.01.11AS PER DWG REV.B PRELIM DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D4704-041 Expandable Pin Assembly	DWG REV B SHEET 1 IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:C 17.01.11AS PER DWG REV.B PRELIM DD VERF:JLM		0.000	
D4708-1 Lanyard	DWG REV C IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS		0.000	
D4709-1 Spring Clip	DWG REV C SHEETS 1,2 IPP REV:A 12.09.11 NEW ISSUE DD VERF:JLM		0.000	
D4711-041 Expandable Pin Assembly, Modified	DWG REV D IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13.03.11 AS PER DWG REV.C DD VERF:JFS		0.000	
MS20613-4C8 Rivet			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	11/14/17	0.00	0.00	Start up container	
120	Small Fab	2 pcs	11/15/17	0.00	0.62	Small Fab	DAS
130	QC	2 pcs	11/15/17	0.00	0.00	QC5	38
140	Packaging	2 pcs	11/15/17	0.00	0.00	Packaging3	9-89
150	QC21-SA	2 Ea	11/15/17	0.00	0.00	QC21	DAS 21 9-89

NOV 06 2017

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D4704-041 B161978	5005720 (1X) 5005720	24 Ea (2 ea)	90-Start up Operation	
D4711-041	Expandable Pin Assembly, Modified	4 Ea (2 ea)	90-Start up Operation	
MS20613-4C8	Rivet F110242-40	2 Ea (4 ea)	90-Start up Operation	
MS20613-4C7	FH138043	2		

Operation 90-Start up Operation

Status: Stock

y	Allocated	Std Qty
0	0	0
0	0	0
0	0	0

Part: **D4704-041 B161978**

Created: 9/30/17 1:29 PM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: **S000267**

Printed By: Goldston, Justin 10/2/17 10:45 AM

10/1/17 12:52 PM Dart.Renwick.Jennifer

DART
AEROSPACE
S005744

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Expandable Pin Assembly

PART NO:	D4704 – 041
Revision:	
Operation:	Start up Operation
Quantity:	1
Change No:	

Mfg Date: 11/03/17

Job No: 161978

Specifications could not be found.

Plex 10/1/17 12:52 PM Dart,Renwick,Jennifer

Work Order Summary

Thursday, September 28, 2017 8:07:32 AM

Page 1 of 1

Criteria : Work Order ID: 161978 Item ID: D4704-041 Product Family SMALL FAB
Work Order Start Dates 5/31/2017 to 5/31/2017 11:59:59 PM Work Order Required Dates 6/2/2017 to 6/2/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	161978	Required Qty	2.0000	Status Code	Released
Item ID	D4704-041	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Expandable Pin Assembly				
Current Acct Value	\$409.282				

Start Date	5/31/2017	Required Date	6/2/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$88.814	\$0.000	\$173.322	\$173.322	100.00%
Labor	\$27.891	\$0.000	\$68.854	\$68.854	100.00%
Outplant	\$9.633	\$0.000	\$4.617	\$4.617	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$76.987	\$0.000	\$155.729	\$155.729	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$203.325	\$0.000	\$402.521	\$402.521	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D4708-1 Lanyard	2.0000		7/6/2017	2.0000	\$8.340
D4709-1 Spring Clip	4.0000		7/6/2017	4.0000	\$22.171
D4711-041 Expandable Pin Assembly, Modified	4.0000		7/12/2017	1.0000	\$172.814
Total Matl Amts:					\$203.325

Work Order ID 161978

Tuesday, May 23, 2017 11:05:28 AM

161978

Page 1

Item ID: D4704-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Expandable Pin Assembly

Start Date: 5/31/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: **MAY 24 2017**

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

**DAS
21
9-89**

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4704

B1

A

**DAS
03
9-89****DR-524**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

**DAS
6
9-89****JUN 14 2017**

120

0.00

120

Small Fab

Memo

ASSEMBLE AS PER I

Small Fab

**4711-641
x24**

130

QC5- Inspect part completeness t

130

QC

Memo

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation		Disposition		Completed By _____	
3280 - 23 23 23		23 23 23		Lead hand / Supervisor Approval Verification _____	
				QC / QA Coordinator Approval _____	
Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimension: ☐ Over/Under tolerar ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Page 2

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Page 1

Tuesday, May 23, 2017 11:05:27 AM

Work Order ID: 161978

161978

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 5/31/2017

Required Date: 6/2/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS IPP REV:B
12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:C 17.01.11AS
PER DWG REV.B PRELIM DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 *D4708-1* Lanyard		Manufactured	No			110	Each	22.0000	1	2			
									**			JUL 06 2017 9-89	DAS
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				22					
				126258				7					
				150504				15					
D4709-1 *D4709-1* Spring Clip		Manufactured	No			110	Each	9.0000	2	4			
									**			JUL 06 2017	DAS
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				9					
				154306				1					
				156360				4					
				157215				4					
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No			110	Each	5.0000	2	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST120				5					
				155796				5					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																					
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<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="5" style="text-align: left;">FAULT CATEGORY</th> </tr> <tr> <td style="width: 10%;">Environment</td><td>☐</td> <td style="width: 10%;">No Re-verification</td><td>☐</td> <td style="width: 10%;">Pressure/Forced</td><td>☐</td> <td style="width: 10%;">Temperature/Cure</td><td>☐</td> <td style="width: 10%;">Power Loss/Surge</td><td>☐</td> <td style="width: 10%;">Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="8" rowspan="2" style="text-align: center; vertical-align: middle;"> OTHER : _____ </td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </table>									Root Cause				FAULT CATEGORY					Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____								Misidentified	☐	Past Due	☐
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Picklist Print

Tuesday, May 23, 2017 11:05:27 AM

Work Order ID: 161978

161978

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 5/31/2017

Required Date: 6/2/2017

Start Qty: 2.00

Required Qty: 2.00

MS20613-4C8

Purchased

No

110

Each

145.0000

4

8

MS20613-4C8

Rivet

Location

Loc Qty

Loc Code

GA

145

120242

145

DQA: _____ Date: _____



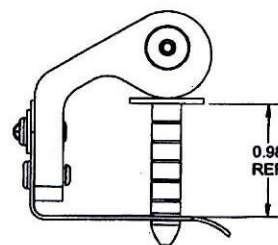
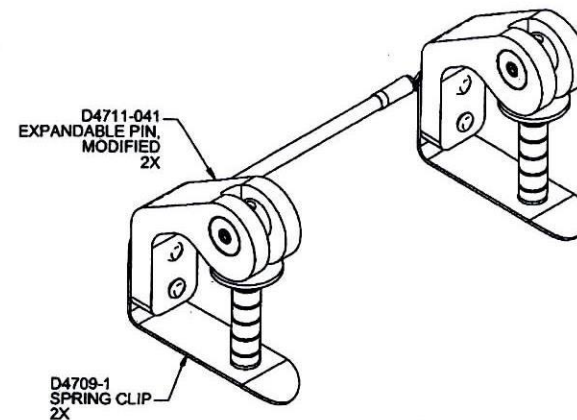
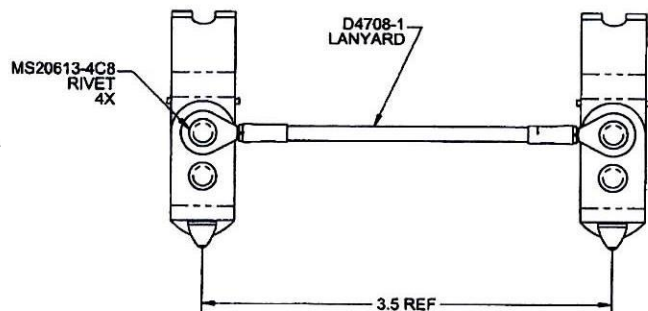
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

ITEM	QTY	P/N	DESCRIPTION
	X	D4704-041	EXPANDABLE PIN ASSY
1	2	D4711-041	EXPANDABLE PIN, MODIFIED
2	1	D4708-1	LANYARD
3	2	D4709-1	SPRING CLIP
4	4	MS20613-4C8	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161978 MJS
1705-24

2012-10-12

D4704-041 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4704-041" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.39 lbs

A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP		
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.09.19		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4704**

TITLE **EXPANDABLE PIN ASSY**

REV. A
SHEET 1 OF 1

SCALE
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